

Work Order ID 156679

Monday, February 06, 2017 1:04:53 PM

156679

Page 1

Item ID: D4042-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib
Start Date: 3/17/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 3/20/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: FEB 07 2017 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4042	A								
100		0.00							
100									
Large Fab	Memo	0.20							
Large Fab	1- Cut as per dwg D4042 2- Drill holes only one side of tube as per dwg 3- Deburr and remove identification markings								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	Identify as per dwg & Stock Location: <u>WAY</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

2x DG 2017/03/142 MAR 24 2017 DAS 24 9-892 MAR 24 2017 DAS 24 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
QC / QA Coordinator Approval 									

Root Cause			FAULT CATEGORY					
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong			
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions			
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance			
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect			
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing			
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved			
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing			
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish			
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread			
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence			
Past Expiry Date ☐	☐ Manufacturing Process	☐ OTHER : _____						
Misidentified ☐	☐ Past Due							

Work Order ID 156679

Monday, February 06, 2017 1:04:53 PM

156679

Page 2

Item ID: D4042-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib
Start Date: 3/17/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 3/20/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
1.30									
QC	Memo	0.03							
Quality Control									

PA. 2017/03/27

DAS
21
9-89

MAR 27 2017

17/3/28 98

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence	
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____				
Misidentified ☐	☐ Past Due					

Picklist Print

Monday, February 06, 2017 1:04:52 PM

Page 1

Work Order ID: 156679

156679

Parent Item: D4042-7

D4042-7

Parent Item Name: Rib

Start Date: 3/17/2017

Required Date: 3/20/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10.01.07 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.750W.049

Purchased

No

100

f

669.5670

5.333

11,22737

M304TS0 750W 049

DC 2017/03/14

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

WA004

669.567

886378 →

12

M134940

38

M135226

8.461

M135711

65

M135899

161.906

M135996

17.9

M136378

378.3

DQA: _____ Date: _____

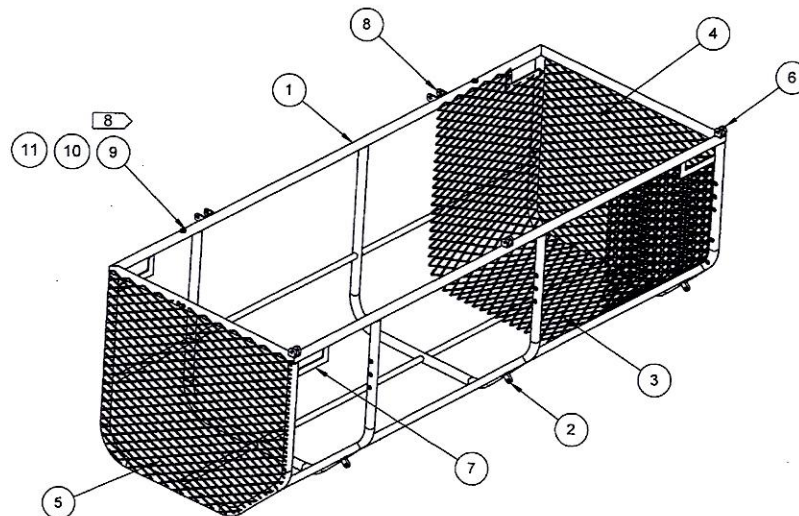


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			



D4042-041 SHORT BASKET ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 28.82 lbs APROX
- 8) INSTALL AFTER FINISH
- 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
- 10) WELD PER DART QSI 004

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4042-041	SHORT BASKET BASE ASSY, LH
1	1	D4042-101	BASKET BASE FRAME ASSY, LH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20600AD4W3	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 156679 MJS
17-02-07

RELEASED
2010-02-16
JMP

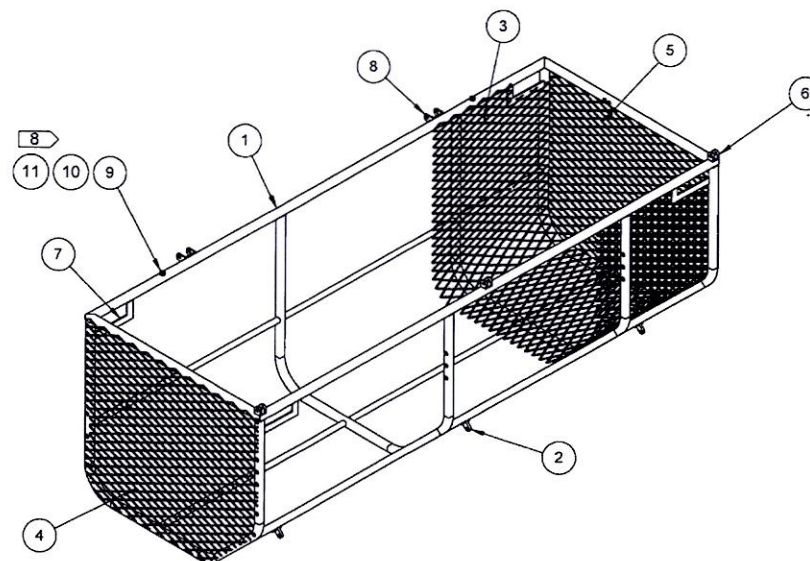
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REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	10.01.29		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4042** REV. A
TITLE **SHORT BASKET BASE ASSY** SCALE NTS
SHEET 1 OF 11

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ITEM	QTY -042	P/N	DESCRIPTION
	X	D4042-042	SHORT BASKET BASE ASSY, RH
1	1	D4042-102	BASKET BASE FRAME ASSY, RH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20600AD4W3	RIVET



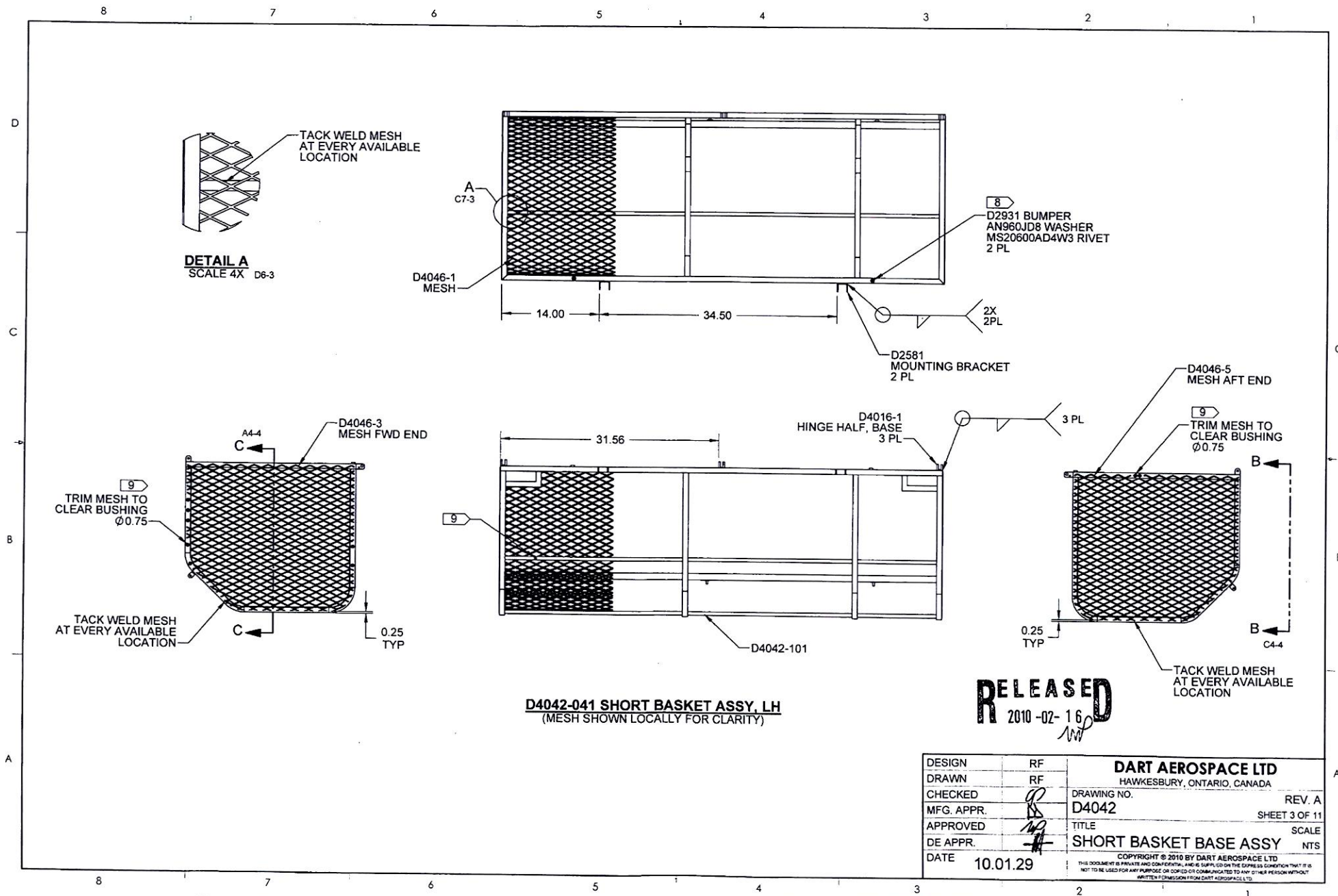
D4042-042 SHORT BASKET ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

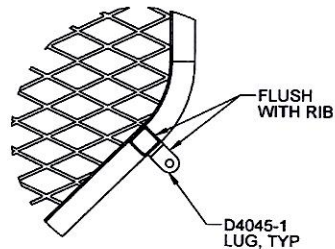
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 28.82 lbs APROX
- 8) INSTALL AFTER FINISH
- 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
- 10) WELD PER DART QSI 004

RELEASED
2010-02-16
JMD

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4042	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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D4044-5
AFT RIB
REF

D4044-043
CENTER RIB ASSY
REF

D4044-041
FWD RIB ASSY
REF

D4045-1
LUG, 3 PL

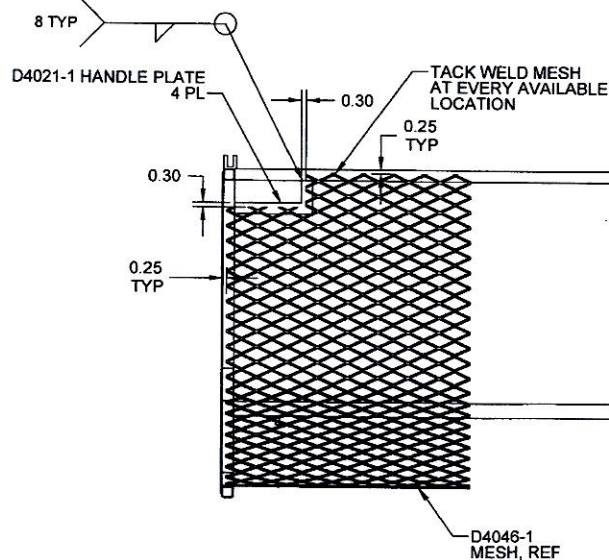
D C7-4

1.96

2.43

2.53

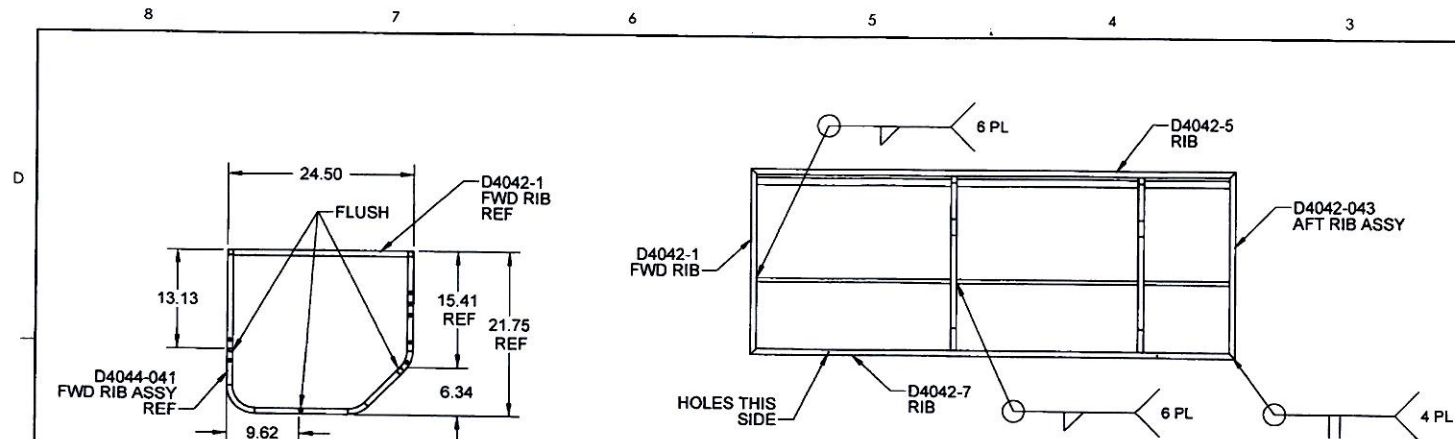
VIEW B-B B1-3
(MESH NOT SHOWN FOR CLARITY)
SCALE 3:2X



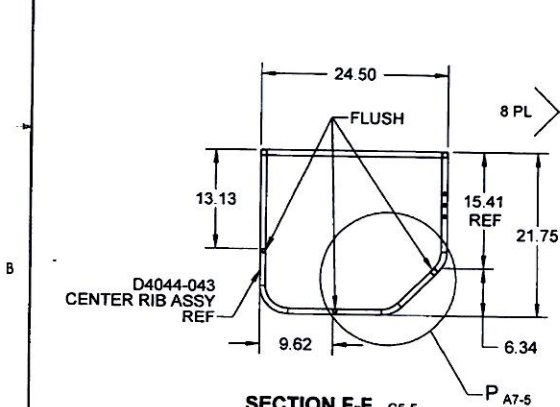
SECTION C-C C7-3
SIMILAR OPPOSITE VIEW
(MESH SHOWN LOCALLY FOR CLARITY)
SCALE 3:2X

RELEASED
2010-02-16
MT

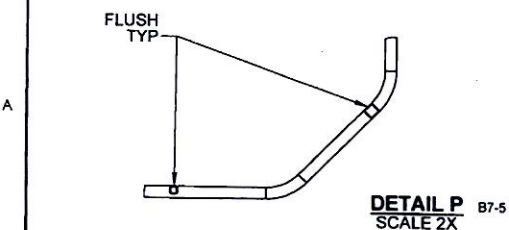
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4042	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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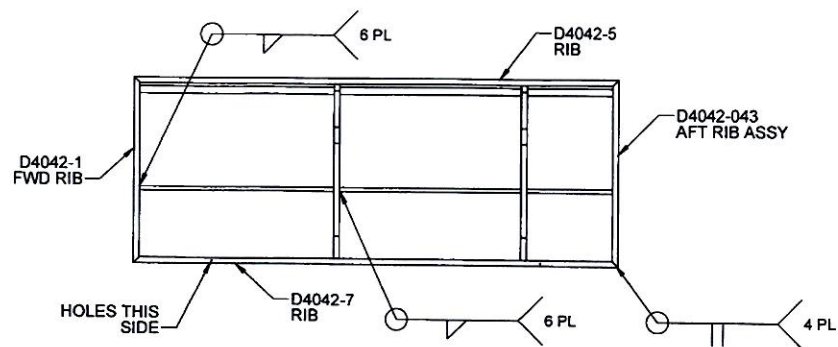
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SECTION F-F C5-5
SECTION G-G C4-5

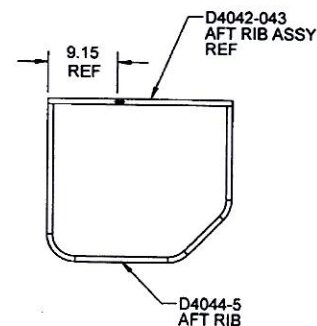


DETAIL P B7-5
SCALE 2X



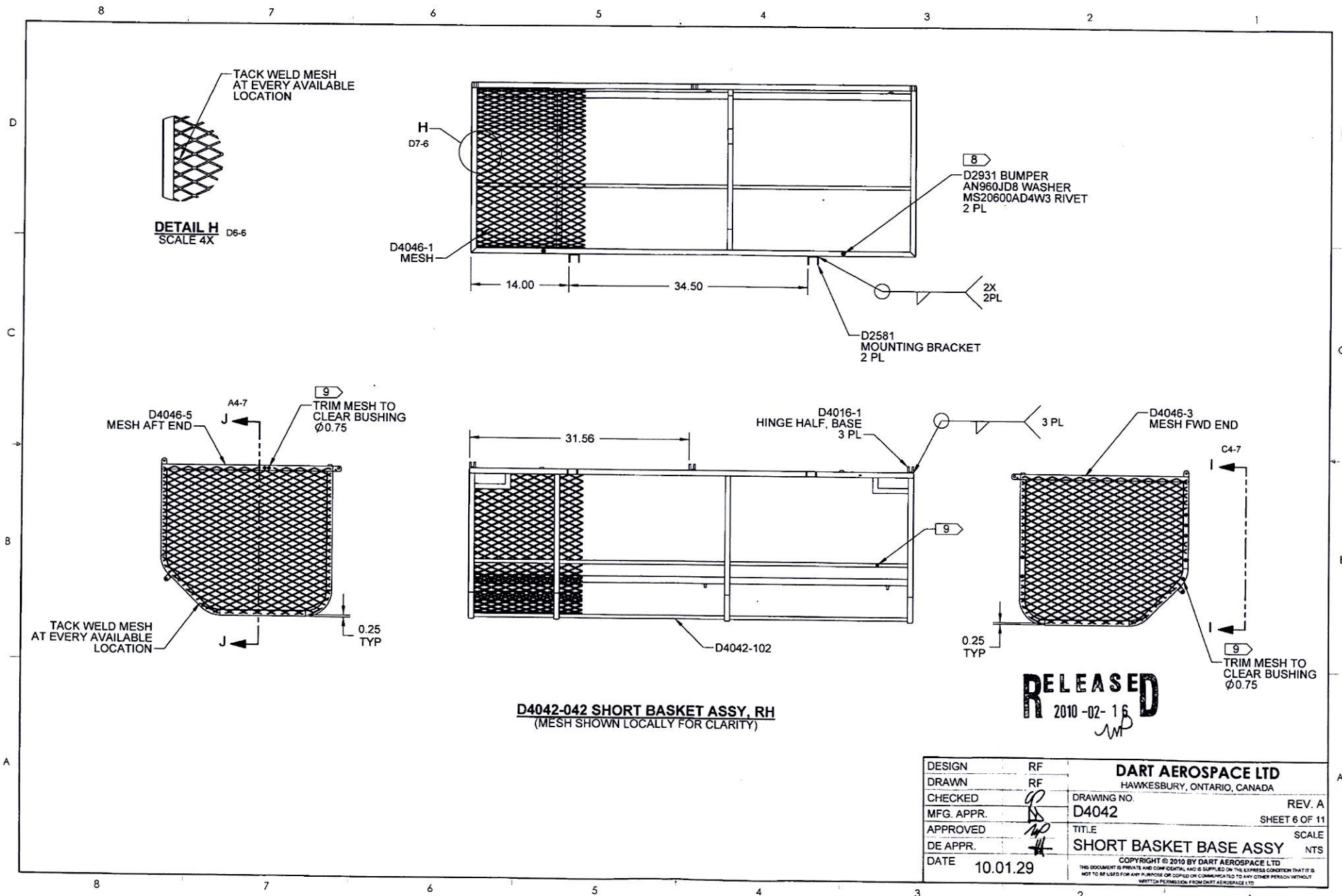
D4042-101 BASKET BASE FRAME ASSY, LH

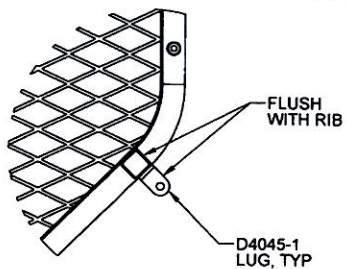
QTY -101	P/N	DESCRIPTION
X	D4042-101	BASKET BASE FRAME ASSY, LH
1	D4042-043	AFT RIB ASSY
1	D4043-041	FWD RIB ASSY
1	D4044-041	FWD RIB ASSY
2	D4044-043	CENTER RIB ASSY
1	D4042-1	FWD RIB
1	D4042-5	INBOARD RIB
1	D4042-7	OUTBOARD RIB
1	D4042-9	FWD RIB
1	D4042-11	CENTER RIB
1	D4042-13	AFT RIB
1	D4043-3	RIB
2	D4043-5	RIB
2	D4043-7	RIB
1	D4044-5	AFT RIB



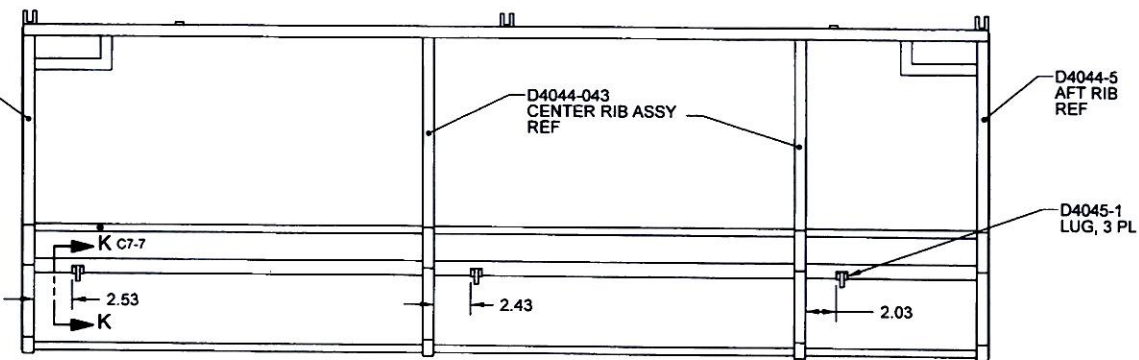
RELEASED
2010-02-16
MP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN	RF		
CHECKED	JP	DRAWING NO. D4042	SHEET 5 OF 11
MFG. APPR.	JS	TITLE	SCALE
APPROVED	JP	SHORT BASKET BASE ASSY	NTS
DE APPR.	JP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.01.29		

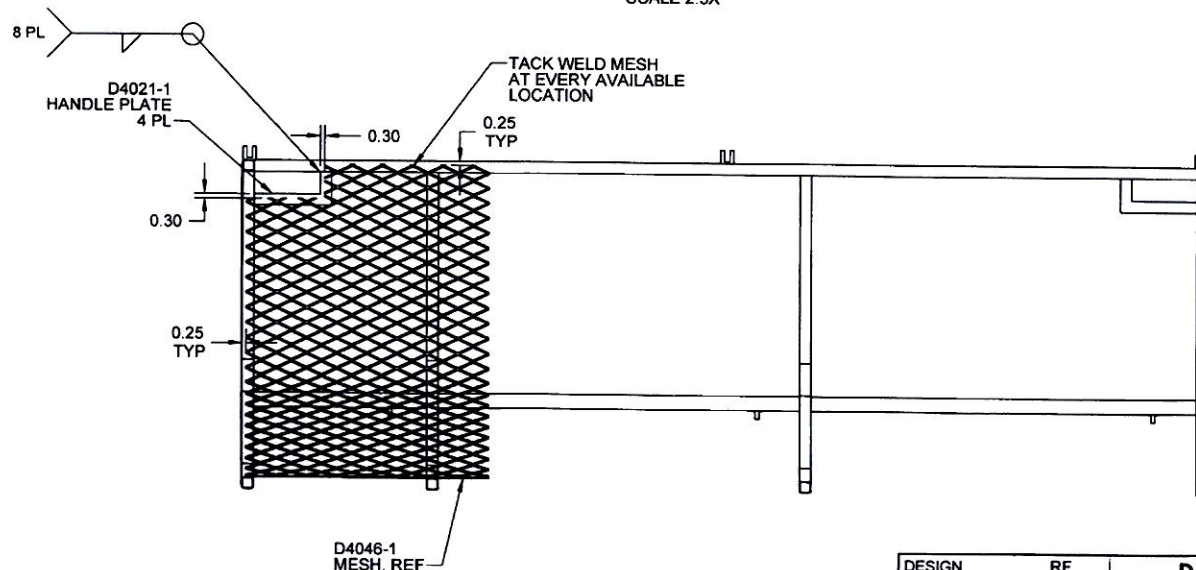




SECTION K-K
SCALE 2X, TYPICAL D6-7



VIEW I-I C7-6
(MESH NOT SHOWN FOR CLARITY)
SCALE 2:3X

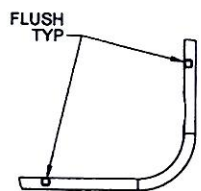
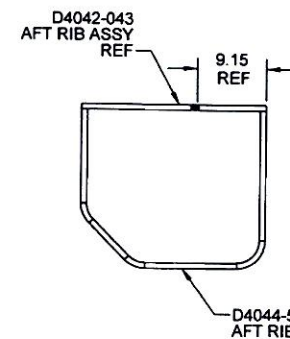
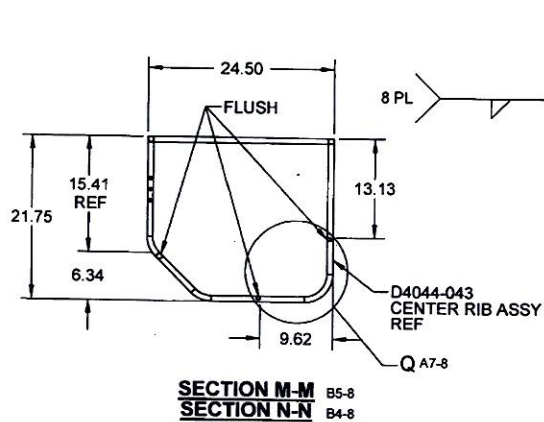
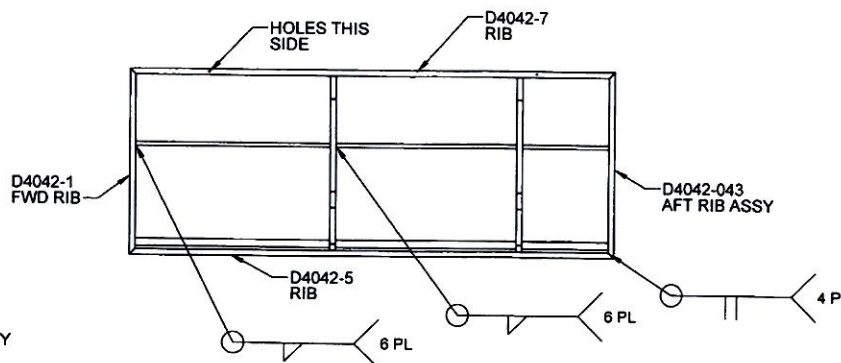
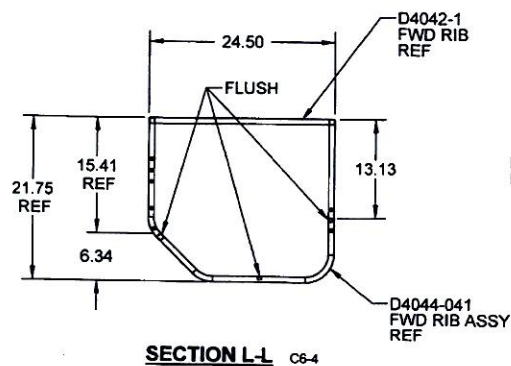


SECTION J-J C7-6
SIMILAR OPPOSITE VIEW
(MESH SHOWN LOCALLY FOR CLARITY)
SCALE 3:2X

RELEASED
2010-02-16
MP

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4042	SHEET 7 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SHORT BASKET BASE ASSY NTS	
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QTY -102	P/N	DESCRIPTION
X	D4042-102	BASKET BASE FRAME ASSY, RH
1	D4042-043	AFT RIB ASSY
1	D4043-041	FWD RIB ASSY
1	D4044-041	FWD RIB ASSY
2	D4044-043	CENTER RIB ASSY
1	D4042-1	FWD RIB
1	D4042-5	INBOARD RIB
1	D4042-7	OUTBOARD RIB
1	D4042-9	FWD RIB
1	D4042-11	CENTER RIB
1	D4042-13	AFT RIB
1	D4043-3	RIB
2	D4043-5	RIB
2	D4043-7	RIB
1	D4044-5	AFT RIB

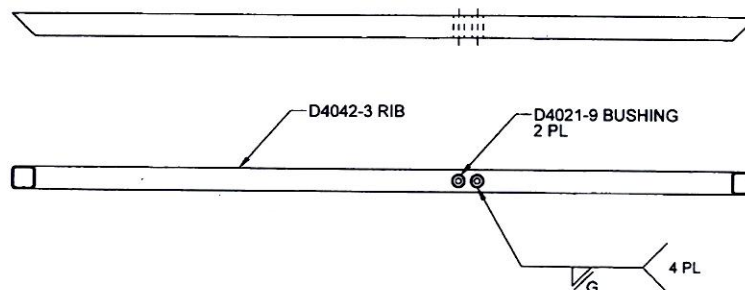


D4042-102 BASKET BASE FRAME ASSY, RH

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4042 TITLE SHORT BASKET BASE ASSY SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.
DRAWN	RF	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	
DATE	10.01.29	REV. A SHEET 8 OF 11

RELEASED
2010-07-16

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4042-043	RIB AFT ASSEMBLY
1	1	D4042-3	AFT RIB
2	2	D4021-9	BUSHING



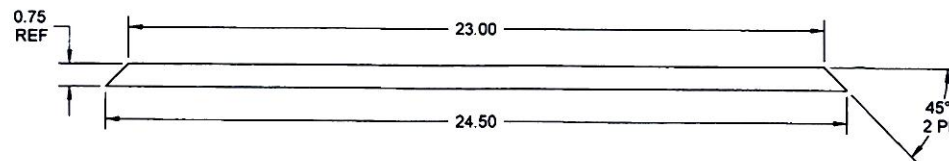
D4042-043 AFT RIB ASSEMBLY

NOTES:

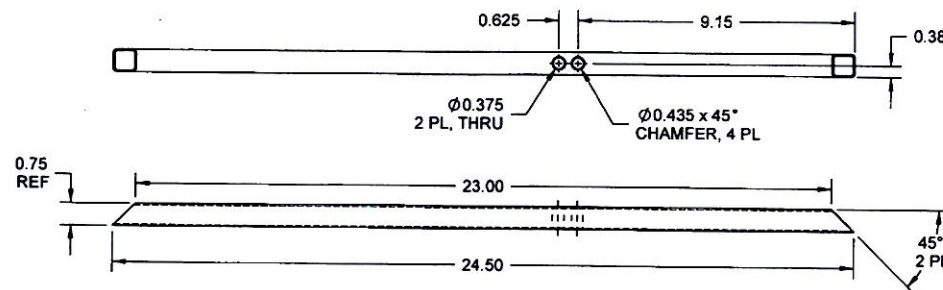
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.91 lbs
- 8) WELD PER DART QSI 004

RELEASED
2010-02-16
AMP

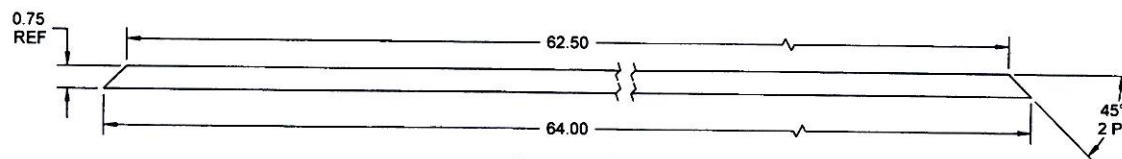
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4042	SHEET 9 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SHORT BASKET BASE ASSY	NTS
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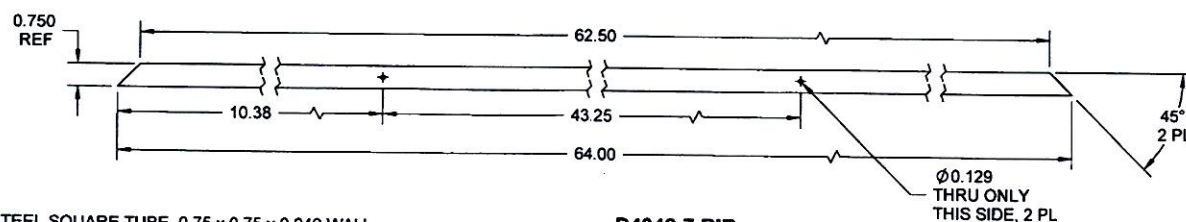
D4042-1 FWD RIB



D4042-3 AFT RIB



D4042-5 RIB



D4042-7 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750V.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4042-1: 0.89 lbs
D4042-3: 0.88 lbs
D4042-5: 2.36 lbs
D4042-7: 2.36 lbs

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DESIGN	RF	DART AEROSPACE LTD	
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